



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3121-141
Job Sheet 169668



Part No: D3121-141

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: ~~Completed~~ *scheduled*

Priority: High

Job Created: 12/18/17

Job Tracking No:

Due Date: 12/22/17

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/21/17	12/21/17	0.00	0.00	Start Up Machining-1		<i>[Signature]</i>
100	Bandsaw	4 pcs	12/21/17	12/21/17	0.00	0.45	Bandsaw1		<i>[Signature]</i>
110	CNC Vertical Machining	4 pcs	12/21/17	12/21/17	0.47	7.84	HAAS1-3		<i>[Signature]</i>
120	QC	4 pcs	12/21/17	12/21/17	0.00	0.00	QC2 Machining-1		<i>[Signature]</i>
130	QC	4 pcs	12/21/17	12/21/17	0.00	0.00	QC8 Machining-1		<i>[Signature]</i>
140	Small Fab	4 pcs	12/22/17	12/22/17	0.00	0.11	Small Fab-2		<i>[Signature]</i>
150	QC	4 pcs	12/22/17	12/22/17	0.00	0.00	QC5		<i>[Signature]</i>
160	Packaging	4 pcs	12/22/17	12/22/17	0.00	0.00	Packaging3-1		<i>[Signature]</i>
170	QC21-SA	4 Ea	12/22/17	12/22/17	0.00	0.00	QC21		<i>[Signature]</i>

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long

Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 3-Scribe batch number

140 - Assemble D3121-141 as per Dwg D3121.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-B1.250X02.000	2	3	0	0
140-Small Fab	D3121-21 <i>F150589</i>	4	50	0	0
	D3121-241 <i>S024941</i>	4	23	0	0

Part Specifications

Specifications could not be found.

M17-4 2.500X1.250 FH135447 S024941

Plex 12/18/17 2:08 PM dart.leroux.jason

DART
AEROSPACE
S024402



Bracket Assembly

Dart Aerospace Ltd.

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PART NO: D3121-141

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/18/17

Job No: 169668

DART AEROSPACE LTD		Work Order: 164023
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.393	✓		micrometer	
0.75	+/-0.030	0.750	✓		caliper	
0.375	+/-0.010	0.375	✓		caliper	
2.14	+/-0.030	2.14	✓		caliper	
1.96	+/-0.030	1.96	✓		caliper	
0.280	+/-0.010	0.280	✓		caliper	
3.330	+/-0.010	3.330	✓		caliper	
3.630	+/-0.010	3.630	✓		caliper	
R0.25	+/-0.030	R0.25	✓		caliper	
R0.375	+/-0.010	R0.375	✓		caliper	
Ø0.201	+/-0.010	0.201	✓		micrometer	
0.100	+/-0.010	0.099	✓		micrometer	
4.580	+/-0.010	4.58	✓		caliper	
6.18	+/-0.030	6.18	✓		caliper	
5.89	+/-0.030	5.89	✓		caliper	
0.080	+/-0.010	0.08	✓		caliper	
0.300	+/-0.010	0.30	✓		caliper	
30°	+/-0.1°	30	✓		caliper	
R0.25	+/-0.030	R0.25	✓		caliper	
0.130	+/-0.010	0.13	✓		caliper	
0.664	+/-0.010	0.66	✓		caliper	
0.381	+/-0.010	0.38	✓		caliper	
0.201	+/-0.010	0.20	✓		caliper	
0.400	+/-0.010	0.40	✓		caliper	
0.580	+/-0.010	0.58	✓		caliper	
100°	+/-0.1°	100	✓		caliper	
0.032	+0.000/-0.010	0.029	✓		micrometer	

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 17-12-19	Date: 17-12-19	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	[Signature]